

CLAIMS

What is claimed is:

1. A lubricated hot rolling method,
using a lubricating oil which contains one kind or two or more kinds among an high-basic alkaline-earth metal phenate, high-basic alkaline-earth metal carboxylate, high-basic alkaline-earth salicylate, or high-basic alkaline-earth metal sulfonate having a basicity of 40 mgKOH/g or higher, and has a viscosity at 40°C of 800 cSt or less, said lubricated hot rolling method comprising the step of:

supplying, when a material to be rolled is supplied between two rolls, said lubricating oil to said rolls, by using a noncombustible gas whose flow rate for one lubricating nozzle is 2000 cm³ or higher per minute, and whose flow velocity is 1 m per second or higher, in 0.01 cm³ or more and 20 cm³ or less per 1 m² of surface area of said rolls, after said lubricating oil is granulated or atomized into particulates having an average size of 1 mm or smaller.

2. The lubricated hot rolling method according to claim 1, wherein

the supply of said lubricating oil is started before said material to be rolled is bit between said two rolls, and an amount supplied of said lubricating oil is 1 m³ or smaller per 1 m² of surface area of said rolls.